

# CPC COOPERATIVE PATENT CLASSIFICATION

## B21D WORKING OR PROCESSING OF SHEET METAL OR METAL TUBES, RODS OR PROFILES WITHOUT ESSENTIALLY REMOVING MATERIAL; PUNCHING METAL ([working or processing of wire B21F](#))

### NOTES

1. This subclass covers cutting or perforating of sheet metal or other stock material
2. This subclass does not cover the working of metal foils in a manner analogous to the working of paper, which is covered by classes [B26](#), [B31](#)

### **Straightening; Restoring form; Bending; Corrugating; Flanging**

- 1/00** Straightening, restoring form or removing local distortions of sheet metal or specific articles made therefrom ([B21D 3/00](#) takes precedence); Stretching sheet metal combined with rolling ([working sheet metal of limited length by stretching B21D 25/00](#); by localised hammering [B21D 31/06](#))
- 1/02 . by rollers ([B21D 1/06](#) takes precedence)
- 1/05 . Stretching combined with rolling
- 1/06 . Removing local distortions
- 1/065 . . {by hammering}
- 1/08 . . of hollow bodies made from sheet metal (of substantially open bodies [B21D 1/10](#); {flattening hollow objects for transport and reforming [B21D 51/14](#)})
- 1/10 . . of specific articles made from sheet metal, e.g. mudguards
- 1/12 . Straightening vehicle body parts or bodies ([B21D 1/14](#) takes precedence)
- 1/14 . Straightening frame structures
- 1/145 . . {Clamps therefor}
- 3/00** Straightening or restoring form of metal rods, metal tubes, metal profiles, or specific articles made therefrom, whether or not in combination with sheet metal parts (straightening of well casings [in situ E21B](#); {straightening rails or rail joints [E01B 31/08](#)})
- 3/005 . {by eccentric turning members}
- 3/02 . by rollers
- 3/04 . . arranged on axes skew to the path of the work
- 3/045 . . . {Workpiece feed channels therefor}
- 3/05 . . arranged on axes rectangular to the path of the work
- 3/06 . . arranged inclined to a revolving flier rolling frame
- 3/08 . . which move in an orbit without rotating round the work
- 3/10 . between rams and anvils or abutments
- 3/12 . by stretching with or without twisting ([by twisting only B21D 11/14](#))
- 3/14 . Recontouring
- 3/16 . of specific articles made from metal rods, tubes, or profiles, e.g. crankshafts, by specially adapted methods or means
- 5/00** Bending sheet metal along straight lines, e.g. to form simple curves ([B21D 11/06](#) - [B21D 11/18](#) take precedence; corrugating sheet metal [B21D 13/00](#); as edge treatment [B21D 19/00](#))
- 5/002 . {Positioning devices}

- 5/004 . {with program control}
- 5/006 . {combined with measuring of bends}
- 5/008 . {combined with heating or cooling of the bends}
- 5/01 . between rams and anvils or abutments
- 5/015 . . {for making tubes}
- 5/02 . on press brakes without making use of clamping means
- 5/0209 . . {Tools therefor}
- 5/0218 . . . {Length adjustment of the punch}
- 5/0227 . . . {Length adjustment of the die}
- 5/0236 . . . {Tool clamping}
- 5/0245 . . . . {Fluid operated}
- 5/0254 . . . {Tool exchanging}
- 5/0263 . . . {Die with two oscillating halves}
- 5/0272 . . {Deflection compensating means}
- 5/0281 . . {Workpiece supporting devices}
- 5/029 . . {with shearing devices}
- 5/04 . on brakes making use of clamping means on one side of the work
- 5/042 . . {With a rotational movement of the bending blade}
- 5/045 . . {With a wiping movement of the bending blade}
- 5/047 . . {Length adjustment of the clamping means}
- 5/06 . by drawing procedure making use of dies or forming-rollers, e.g. making profiles
- 5/08 . . making use of forming-rollers ([B21D 5/12](#) takes precedence)
- 5/083 . . . {for obtaining profiles with changing cross-sectional configuration}
- 5/086 . . . {for obtaining closed hollow profiles}
- 5/10 . . for making tubes
- 5/12 . . . making use of forming-rollers
- 5/14 . by passing between rollers ([B21D 5/06](#) takes precedence)
- 5/143 . . {making use of a mandrel}
- 5/146 . . {one roll being covered with deformable material}
- 5/16 . Folding; Pleating
- 7/00** Bending rods, profiles, or tubes ([B21D 11/02](#) - [B21D 11/18](#) take precedence; using mandrels or the like [B21D 9/00](#))
- 7/02 . over a stationary forming member; by use of a swinging forming member or abutment
- 7/021 . . {Construction of forming members having more than one groove}
- 7/022 . . over a stationary forming member only
- 7/0225 . . . {using pulling members}
- 7/024 . . by a swinging forming member
- 7/025 . . . and pulling or pushing the ends of the work

- 7/028 . . . and altering the profile at the same time, e.g. forming bumpers
- 7/03 . . Apparatus with means to keep the profile in shape
- 7/04 . . over a movably-arranged forming member  
([B21D 7/02](#) takes precedence)
- 7/06 . . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- 7/063 . . {Pliers with forming dies}
- 7/066 . . {combined with oscillating members}
- 7/08 . . by passing between rollers or through a curved die
- 7/085 . . {by passing through a curved die}
- 7/10 . . by abutting members and flexible bending means, e.g. with chains, ropes
- 7/12 . . with programme control
- 7/14 . . combined with measuring of bends or lengths
- 7/16 . . Auxiliary equipment, e.g. for heating or cooling of bends
- 7/162 . . {Heating equipment}
- 7/165 . . {Cooling equipment}
- 7/167 . . {Greasing}
- 9/00 Bending tubes using mandrels or the like**  
([B21D 11/02](#) - [B21D 11/18](#) take precedence)
- 9/01 . . the mandrel being flexible and engaging the entire tube length
- 9/03 . . and built-up from loose elements, e.g. series of balls
- 9/04 . . the mandrel being rigid
- 9/05 . . co-operating with forming members
- 9/055 . . {Construction of forming members having more than one groove}
- 9/07 . . with one or more swinging forming members engaging tube ends only
- 9/073 . . . {with one swinging forming member}
- 9/076 . . . {with more swinging forming members}
- 9/08 . . in press brakes or between rams and anvils or abutments; Pliers with forming dies
- 9/085 . . {Pliers with forming dies}
- 9/10 . . by passing between rollers
- 9/12 . . by pushing over a curved mandrel; by pushing through a curved die
- 9/125 . . {by pushing through a curved die}
- 9/14 . . Wrinkle-bending, i.e. bending by corrugating
- 9/15 . . using filling material of indefinite shape, e.g. sand, plastic material (filling of tubes with such material [B21D 9/16](#))
- 9/16 . . Auxiliary equipment, e.g. machines for filling tubes with sand
- 9/165 . . {Machines for filling tubes with sand}
- 9/18 . . for heating or cooling of bends
- 11/00 Bending not restricted to forms of material mentioned in only one of groups [B21D 5/00](#), [B21D 7/00](#), [B21D 9/00](#); Bending not provided for in groups [B21D 5/00](#) - [B21D 9/00](#) (corrugating or bending into wave form [B21D 13/00](#), [B21D 15/00](#); flanging [B21D 19/00](#)); Twisting**
- 11/02 . . Bending by stretching or pulling over a die (working sheet metal of limited length by stretching [B21D 25/00](#))
- 11/06 . . Bending into helical or spiral form; Forming a succession of return bends, e.g. serpentine form (making helically seamed tubing [B21C 37/12](#))
- 11/07 . . Making serpentine-shaped articles by bending essentially in one plane
- 11/08 . . Bending by altering the thickness of part of the cross-section of the work ([B21D 11/06](#) takes precedence)
- 11/085 . . {by locally stretching or upsetting}
- 11/10 . . Bending specially adapted to produce specific articles, e.g. leaf springs {(making or bending leaf springs [B21D 53/886](#))}
- 11/12 . . the articles being reinforcements for concrete
- 11/125 . . . {Bending wire nets}
- 11/14 . . Twisting
- 11/15 . . Reinforcing rods for concrete
- 11/16 . . Crankshafts
- 11/18 . . Jogging
- 11/20 . . Bending sheet metal, not otherwise provided for
- 11/203 . . {Round bending}
- 11/206 . . {Curving corrugated sheets}
- 11/22 . . Auxiliary equipment, e.g. positioning devices
- 13/00 Corrugating sheet metal, rods or profiles; Bending sheet metal, rods or profiles into wave form** ([tubes \[B21D 15/00\]\(#\)](#))
- 13/02 . . by pressing
- 13/04 . . by rolling
- 13/045 . . {the corrugations being parallel to the feeding movement}
- 13/06 . . by drawing
- 13/08 . . by combined methods
- 13/10 . . into a peculiar profiling shape
- 15/00 Corrugating tubes (wrinkle-bending using mandrels or the like [B21D 9/14](#))**
- 15/02 . . longitudinally
- 15/03 . . by applying fluid pressure
- 15/04 . . transversely, e.g. helically
- 15/06 . . . annularly {(with thinning [B21C 37/205](#))}
- 15/10 . . by applying fluid pressure
- 15/105 . . . {by applying elastic material}
- 15/12 . . Bending tubes into wave form
- 17/00 Forming single grooves in sheet metal or tubular or hollow articles**
- 17/02 . . by pressing (grooving or notching of bolts, studs, or the like [B21K 1/54](#))
- 17/025 . . {by pressing tubes axially}
- 17/04 . . by rolling
- 19/00 Flanging or other edge treatment, e.g. of tubes** (connecting by making use of folds [B21D 39/00](#); flaring-out tube ends [B21D 41/02](#))
- 19/005 . . {Edge deburring or smoothing}
- 19/02 . . by continuously-acting tools moving along the edge (edge-curling [B21D 19/12](#))
- 19/04 . . shaped as rollers
- 19/043 . . . {for flanging edges of plates}
- 19/046 . . . {for flanging edges of tubular products}
- 19/06 . . . working inwardly
- 19/08 . . by single or successive action of pressing tools, e.g. vice jaws
- 19/082 . . . {for making negative angles}
- 19/084 . . . {with linear cams, e.g. aerial cams}
- 19/086 . . . {with rotary cams}
- 19/088 . . {for flanging holes}

- 19/10 . . working inwardly
- 19/12 . Edge-curling
- 19/14 . . Reinforcing edges, e.g. armouring same
- 19/16 . Reverse flanging of tube ends
- 21/00 Combined processes according to methods covered by groups [B21D 1/00](#) - [B21D 19/00](#)**

**Stamping, Spinning, Deep-drawing; Working sheet metal of limited length by stretching; Punching**

- 22/00 Shaping without cutting, by stamping, spinning, or deep-drawing (otherwise than using rigid devices or tools or yieldable or resilient pads [B21D 26/00](#))**
- 22/02 . Stamping using rigid devices or tools
- 22/022 . . {by heating the blank or stamping associated with heat treatment ([C21D](#) takes precedence)}
- 22/025 . . {for tubular articles}
- 22/027 . . {for flattening the ends of corrugated sheets}
- 22/04 . . for dimpling (combined with perforating [B21D 28/24](#))
- 22/06 . . having relatively-movable die parts
- 22/08 . . with die parts on rotating carriers
- 22/10 . Stamping using yieldable or resilient pads
- 22/105 . . {of tubular products}
- 22/12 . . using enclosed flexible chambers
- 22/125 . . . {of tubular products}
- 22/14 . Spinning
- 22/16 . . over shaping mandrels or formers
- 22/18 . . using tools guided to produce the required profile
- 22/185 . . . {making bombed objects}
- 22/20 . Deep-drawing (special deep-drawing arrangements in, or in connection with, presses [B21D 24/00](#))
- 22/201 . . {Work-pieces; preparation of the work-pieces, e.g. lubricating, coating}
- 22/203 . . {of compound articles}
- 22/205 . . {Hydro-mechanical deep-drawing}
- 22/206 . . {articles from a strip in several steps, the articles being coherent with the strip during the operation}
- 22/208 . . {by heating the blank or deep-drawing associated with heat treatment ([C21D](#) takes precedence)}
- 22/21 . . without fixing the border of the blank
- 22/22 . . with devices for holding the edge of the blanks ([B21D 22/24](#) - [B21D 22/30](#) take precedence; shaping over a die without external former [B21D 11/02](#))
- 22/225 . . . {with members for radially pushing the blanks}
- 22/24 . . involving two drawing operations having effects in opposite directions with respect to the blank
- 22/26 . . for making peculiarly, e.g. irregularly, shaped articles
- 22/28 . . of cylindrical articles using consecutive dies
- 22/283 . . . {with ram and dies aligning means}
- 22/286 . . . {with lubricating or cooling means}
- 22/30 . . to finish articles formed by deep-drawing
- 24/00 Special deep-drawing arrangements in, or in connection with, presses**
- 24/005 . {Multi-stage presses}
- 24/02 . Die-cushions
- 24/04 . Blank holders; Mounting means therefor
- 24/06 . . Mechanically spring-loaded blank holders
- 24/08 . . Pneumatically or hydraulically loaded blank holders
- 24/10 . Devices controlling or operating blank holders independently, or in conjunction with dies
- 24/12 . . mechanically
- 24/14 . . pneumatically or hydraulically
- 24/16 . Additional equipment in association with the tools, e.g. for shearing, for trimming
- 25/00 Working sheet metal of limited length by stretching, e.g. for straightening**
- 25/02 . by pulling over a die
- 25/04 . Clamping arrangements
- 26/00 Shaping without cutting otherwise than using rigid devices or tools or yieldable or resilient pads, i.e. applying fluid pressure or magnetic forces (stamping using resilient pads [B21D 22/10](#))**
- 26/02 . by applying fluid pressure
- 26/021 . . Deforming sheet bodies
- 26/023 . . . including an additional treatment performed by fluid pressure, e.g. perforating
- 26/025 . . . Means for controlling the clamping or opening of the moulds
- 26/027 . . . Means for controlling fluid parameters, e.g. pressure or temperature
- 26/029 . . . Closing or sealing means
- 26/031 . . . Mould construction ([B21D 26/025](#) - [B21D 26/029](#) take precedence)
- 26/033 . . Deforming tubular bodies (corrugating tubes by applying fluid pressure [B21D 15/03](#), [B21D 15/10](#))
- 26/035 . . . including an additional treatment performed by fluid pressure, e.g. perforating
- 26/037 . . . Forming branched tubes
- 26/039 . . . Means for controlling the clamping or opening of the moulds
- 26/041 . . . Means for controlling fluid parameters, e.g. pressure or temperature
- 26/043 . . . Means for controlling the axial pusher
- 26/045 . . . Closing or sealing means
- 26/047 . . . Mould construction ([B21D 26/037](#) - [B21D 26/045](#) take precedence)
- 26/049 . . . Deforming bodies having a closed end
- 26/051 . . . Deforming double-walled bodies
- 26/053 . . characterised by the material of the blanks
- 26/055 . . . Blanks having super-plastic properties
- 26/057 . . . Tailored blanks
- 26/059 . . . Layered blanks
- 26/06 . . by shock waves
- 26/08 . . . generated by explosives, e.g. chemical explosives
- 26/10 . . . generated by evaporation, e.g. of wire, of liquids
- 26/12 . . . initiated by spark discharge
- 26/14 . applying magnetic forces
- 28/00 Shaping by press-cutting; Perforating**
- 28/002 . {Drive of the tools ([B21D 28/007](#) and [B21D 28/20](#) take precedence)}
- 28/005 . . {Adjustment of the punch stroke for compensating wear}
- 28/007 . {Explosive cutting or perforating}
- 28/02 . Punching blanks or articles with or without obtaining scrap (cutting nails or pins from strips or sheet material [B21G 3/26](#)); Notching

28/04	. . Centering the work; Positioning the tools	35/001	. {Shaping combined with punching, e.g. stamping and perforating}
28/06	. . Making more than one part out of the same blank; Scrapless working	35/002	. {Processes combined with methods covered by groups <a href="#">B21D 1/00</a> - <a href="#">B21D 31/00</a> }
28/08	. . . Zig-zag sequence working	35/003	. . {Simultaneous forming, e.g. making more than one part per stroke ( <a href="#">B21D 26/06</a> takes precedence)}
28/10	. . Incompletely punching in such a manner that the parts are still coherent with the work	35/005	. . {characterized by the material of the blank or the workpiece ( <a href="#">B21D 26/053</a> takes precedence)}
28/12	. . Punching using rotatable carriers	35/006	. . . {Blanks having varying thickness, e.g. tailored blanks}
28/125	. . . {with multi-tools}	35/007	. . . {Layered blanks ( <a href="#">B21D 22/203</a> takes precedence; joining superposed plates <a href="#">B21D 39/031</a> , <a href="#">B21D 39/034</a> , <a href="#">B21D 39/035</a> )}
28/14	. . Dies (ejecting or stripping-off devices arranged in punching machines or tools <a href="#">B21D 45/00</a> )	35/008	. . {involving vibration, e.g. ultrasonic}
28/145	. . . {with means for slug retention, e.g. a groove}	<b>37/00</b>	<b>Tools as parts of machines covered by this subclass (forms or constructions of tools uniquely adapted for particular operations, <a href="#">see the relevant groups for the operations</a>)</b>
28/16	. . Shoulder or burr prevention {, e.g. fine-blanking}	37/01	. Selection of materials
28/18	. . Yieldable, e.g. rubber, punching pads	37/02	. Die constructions enabling assembly of the die parts in different ways ( <a href="#">B21D 37/06</a> takes precedence)
28/20	. . Applications of drives {for reducing noise or wear}	37/04	. Movable or exchangeable mountings for tools
28/22	. . Notching the peripheries of circular blanks, e.g. laminations for dynamo-electric machines	37/06	. . Pivotaly-arranged tools, e.g. disengageable ( <a href="#">die sets with dies pivoted to one another B21D 37/12</a> )
28/24	. Perforating, i.e. punching holes	37/08	. Dies with different parts for several steps in a process
28/243	. . {in profiles}	37/10	. Die sets; Pillar guides
28/246	. . {Selection of punches}	37/12	. . Particular guiding equipment, {e.g. pliers}; Special arrangements for interconnection or co-operation of dies
28/26	. . in sheets or flat parts	37/14	. Particular arrangements for handling and holding in place complete dies
28/265	. . . {with relative movement of sheet and tools enabling the punching of holes in predetermined locations of the sheet, e.g. holes punching with template}	37/142	. . {Spotting presses}
28/28	. . in tubes or other hollow bodies	37/145	. . {Die storage magazines}
28/285	. . . {punching outwards}	37/147	. . {Tool exchange carts}
28/30	. . in annular parts, e.g. rims	37/16	. Heating or cooling
28/32	. . in other articles of special shape	37/18	. Lubricating, {e.g. lubricating tool and workpiece simultaneously (lubricating workpieces for deep-drawing <a href="#">B21D 22/201</a> )}
28/325	. . . {using cam or wedge mechanisms, e.g. aerial cams}	37/20	. Making tools by operations not covered by a single other subclass
28/34	. . Perforating tools; Die holders	37/205	. . {Making cutting tools}
28/343	. . . {Draw punches}	<b>39/00</b>	<b>Application of procedures in order to connect objects or parts, e.g. coating with sheet metal otherwise than by plating ({joining mitred profiles <a href="#">B21D 53/745</a>; } riveting <a href="#">B21J</a>; uniting components by forging or pressing to form integral members <a href="#">B21K 25/00</a>; welding <a href="#">B23K</a>; press-fitting, force-fitting, or shrinking in general <a href="#">B23P 11/00</a>, <a href="#">B21D 19/00</a>; by adhesives <a href="#">F16B 11/00</a>; {Connections as such <a href="#">F16L</a>, <a href="#">F16B</a>}); Tube expanders</b>
28/346	. . . {length adjustable perforating tools}	39/02	. of sheet metal by folding, e.g. connecting edges of a sheet to form a cylinder
28/36	. . using rotatable work or tool holders	39/021	. . . {for panels, e.g. vehicle doors}
<b>31/00</b>	<b>Other methods for working sheet metal, metal tubes, metal profiles (deforming one surface of tubes helically by rolling <a href="#">B21H 3/00</a>; upsetting <a href="#">B21J 5/08</a>; working metal by removing material therefrom <a href="#">B23</a>; embossing <a href="#">B44B</a>)</b>	39/023	. . . {using rollers}
31/005	. {Incremental shaping or bending, e.g. stepwise moving a shaping tool along the surface of the workpiece ( <a href="#">B21D 22/14</a> takes precedence)}	39/025	. . {Hand tools}
31/02	. Stabbing or piercing, e.g. for making sieves (dimpling <a href="#">B21D 22/04</a> ; perforating by punching <a href="#">B21D 28/24</a> )	39/026	. . {Reinforcing the connection by locally deforming}
31/04	. Expanding other than provided for in groups <a href="#">B21D 1/00</a> - <a href="#">B21D 28/00</a> , e.g. for making expanded metal ( <a href="#">B21D 47/00</a> takes precedence; enlarging tube ends <a href="#">B21D 41/02</a> )	39/028	. . {Reinforcing the connection otherwise than by deforming, e.g. welding}
31/043	. . {Making use of slitting discs or punch cutters}	39/03	. of sheet metal otherwise than by folding
31/046	. . {making use of rotating cutters}		
31/06	. Deforming sheet metal, tubes or profiles by sequential impacts, e.g. hammering, beating, peen forming ( <a href="#">forging hammers B21J 7/00</a> )		
<b>33/00</b>	<b>Special measures in connection with working metal foils, e.g. gold foils (cutting or perforating of metal foil analogous to paper <a href="#">B26</a>)</b>		
<b>35/00</b>	<b>Combined processes according to {or processes combined with} methods covered by groups <a href="#">B21D 1/00</a> - <a href="#">B21D 31/00</a> (<a href="#">B21D 21/00</a> takes precedence)</b>		



39/031	. . {Joining superposed plates by locally deforming without slitting or piercing}	43/028	. . {Tools travelling with material, e.g. flying punching machines}
39/032	. . . {by fitting a projecting part integral with one plate in a hole of the other plate}	43/04	. . by means in mechanical engagement with the work
39/034	. . {Joining superposed plates by piercing}	43/05	. . . specially adapted for multi-stage presses { <a href="#">(B21D 43/145 takes precedence)</a> }
39/035	. . {Joining superposed plates by slitting}	43/052	. . . . {Devices having a cross bar}
39/037	. . {Interlocking butt joints}	43/055	. . . . {Devices comprising a pair of longitudinally and laterally movable parallel transfer bars}
39/038	. . {Perpendicular plate connections}	43/057	. . . . {Devices for exchanging transfer bars or grippers; Idle stages, e.g. exchangeable}
39/04	. of tubes with tubes; of tubes with rods {(crimped pipe joints as such <a href="#">F16L 13/14</a> )}	43/06	. . . by positive or negative engaging parts co-operating with corresponding parts of the sheet or the like to be processed, e.g. carrier bolts or grooved section in the carriers
39/042	. . {using explosives (by explosive welding <a href="#">B23K 20/08</a> )}	43/08	. . . by rollers { <a href="#">(B21D 43/145 takes precedence)</a> }
39/044	. . {perpendicular}	43/09	. . . . by one or more pairs of rollers for feeding sheet or strip material
39/046	. . {Connecting tubes to tube-like fittings}	43/10	. . . by grippers { <a href="#">(B21D 43/055, B21D 43/057, B21D 43/145 take precedence)</a> }
39/048	. . {using presses for radially crimping tubular elements}	43/105	. . . . {Manipulators, i.e. mechanical arms carrying a gripper element having several degrees of freedom}
39/06	. of tubes in openings, e.g. rolling-in	43/11	. . . . for feeding sheet or strip material
39/063	. . {for assembling ladders}	43/12	. . . by chains or belts { <a href="#">(B21D 43/145 takes precedence)</a> }
39/066	. . {using explosives}	43/13	. . . by linearly moving tables
39/08	. Tube expanders	43/14	. . . by turning devices, e.g. turn-tables
39/10	. . with rollers for expanding only	43/145	. . . . {Turnover devices, i.e. by turning about a substantially horizontal axis}
39/12	. . with rollers for expanding and flanging	43/16	. . by gravity, e.g. chutes
39/14	. . with balls	43/18	. . by means in pneumatic or magnetic engagement with the work
39/16	. . with torque limiting devices	43/20	. Storage arrangements; Piling or unpling ( <a href="#">in general B65G, (B65H)</a> )
39/18	. . Rollers of special shape	43/22	. . Devices for piling sheets
39/20	. . with mandrels, e.g. expandable	43/24	. . Devices for removing sheets from a stack
39/203	. . . {expandable by fluid or elastic material}	43/26	. Stops
39/206	. . . . {by axially compressing the elastic material}	43/28	. Associations of cutting devices therewith
<b>41/00</b>	<b>Application of procedures in order to alter the diameter of tube ends (<a href="#">B21D 39/00 takes precedence</a>; {plastic tubes <a href="#">B29C 57/08</a>})</b>	43/282	. . {Discharging crop ends or the like}
41/02	. Enlarging	43/285	. . {Devices for handling elongated articles, e.g. bars, tubes or profiles ( <a href="#">B21D 43/282, B21D 43/287 take precedence</a> )}
41/021	. . {by means of tube-flaring hand tools}	43/287	. . {Devices for handling sheet or strip material ( <a href="#">B21D 43/282 takes precedence</a> )}
41/023	. . . {comprising rolling elements}	<b>45/00</b>	<b>Ejecting or stripping-off devices arranged in machines or tools dealt with in this subclass</b>
41/025	. . {by means of impact-type swaging hand tools}	45/003	. {in punching machines or punching tools}
41/026	. . {by means of mandrels}	45/006	. . {Stripping-off devices}
41/028	. . . {expandable mandrels}	45/02	. Ejecting devices
41/04	. Reducing; Closing	45/04	. . interrelated with motion of tool
41/045	. . {Closing}	45/06	. Stripping-off devices
<b>43/00</b>	<b>Feeding, positioning or storing devices combined with, or arranged in, or specially adapted for use in connection with, apparatus for working or processing sheet metal, metal tubes or metal profiles; Associations therewith of cutting devices (cutting devices associated with the tool, <a href="#">see the relevant group for the tool</a>)</b>	45/065	. . {for deep-drawn cans, e.g. using stripping fingers}
43/003	. {Positioning devices ( <a href="#">B21D 28/04 and B21D 28/265 take precedence</a> ; stops <a href="#">B21D 43/26; centering moving strips B21D 43/023</a> )}	45/08	. . interrelated with motion of tool
43/006	. {Feeding elongated articles, such as tubes, bars, or profiles}	45/10	. Combined ejecting and stripping-off devices
43/02	. Advancing work in relation to the stroke of the die or tool		
43/021	. . {Control or correction devices in association with moving strips}		
43/022	. . . {Loop-control}		
43/023	. . . {Centering devices, e.g. edge guiding}		
43/025	. . {Fault detection, e.g. misfeed detection}		
43/026	. . {Combination of two or more feeding devices provided for in <a href="#">B21D 43/04 - B21D 43/18</a> }		
43/027	. . {Combined feeding and ejecting devices}		
			<b><u>Processing sheet metal or metal tubes, or processing metal profiles according to any of groups <a href="#">B21D 1/00 - B21D 45/00</a>, in the manufacture of finished or semi-finished articles</u></b>
		<b>47/00</b>	<b>Making rigid structural elements or units, e.g. honeycomb structures</b>

47/005	. {Making gratings}	51/36	. . collapsible or like thin-walled tubes, e.g. for toothpaste
47/01	. beams or pillars	51/365	. . . {involving fixing closure members to the tubes, e.g. nozzles}
47/02	. . by expanding	51/38	. . Making inlet or outlet arrangements of cans, tins, baths, bottles, or other vessels; Making can ends; Making closures
47/04	. composite sheet metal profiles	51/383	. . . {scoring lines, tear strips or pulling tabs}
<b>49/00</b>	<b>Sheathing or stiffening objects (by winding wire or tape thereon B65H 54/00, B65H 81/00; specially adapted for manufacturing conductors or cables H01B 13/26)</b>	51/386	. . . . {on the side-wall of containers}
49/005	. {Hollow objects}	51/40	. . . Making outlet openings, e.g. bung holes
<b>51/00</b>	<b>Making hollow objects (from thick-walled or non uniform tubes B21K 21/00)</b>	51/42	. . . . Making or attaching spouts
51/02	. characterised by the structure of the objects {(B21D 51/26 takes precedence)}	51/44	. . . Making closures, e.g. caps (folded of thin metal foils in the way of making paper caps B31D 5/00; making closures in conjunction with applying same B67B)
	<b>NOTE</b>	51/443	. . . . {easily removable closures, e.g. by means of tear strips}
	Making hollow objects characterised both by their structure and by their use is classified only in group B21D 51/16	51/446	. . . . {Feeding or removal of material}
51/04	. . built-up objects, e.g. objects with rigidly-attached bottom or cover	51/46	. . . . Placing sealings or sealing material {(moulding plastic sealing material into closure members B29C 70/80)}
51/06	. . folded objects	51/48	. . . . Making crown caps
51/08	. . ball-shaped objects	51/50	. . . . Making screw caps
51/10	. . conically or cylindrically shaped objects	51/52	. . boxes, cigarette cases, or the like
51/12	. . objects with corrugated walls	51/54	. . cartridge cases, e.g. for ammunition, for letter carriers in pneumatic-tube plants
51/14	. . Flattening hollow objects for transport or storage; Re-forming same (making tubes from doubled flat material B21C 37/14)	<b>53/00</b>	<b>Making other particular articles (making wire fabrics B21F; making chains or chain parts B21L)</b>
51/16	. characterised by the use of the objects (making heat exchangers B21D 53/02)	53/02	. heat exchangers {or parts thereof}, e.g. radiators, condensers {fins, headers} (making finned or ribbed tubes by fixing strip material or the like to tubes B21C 37/22)
51/18	. . vessels, e.g. tubs, vats, tanks, sinks, or the like	53/022	. . {Making the fins}
51/20	. . . barrels	53/025	. . . {Louvered fins}
51/22	. . . pots, e.g. for cooking	53/027	. . {by helically or spirally winding elongated elements}
51/24	. . high-pressure containers, e.g. boilers, bottles	53/04	. . of sheet metal
51/26	. . cans or tins; Closing same in a permanent manner (making outlet arrangements B21D 51/38; welding or soldering B23K)	53/045	. . . {by inflating partially united plates}
51/2607	. . . {Locally embossing the walls of formed can bodies (B44B 5/00, B44C 1/24, B44C 3/085 take precedence; bulging B21D 51/2646)}	53/06	. . of metal tubes
51/2615	. . . {Edge treatment of cans or tins}	53/08	. . of both metal tubes and sheet metal (connecting tubes in openings B21D 39/06)
51/2623	. . . . {Curling}	53/085	. . . {with fins places on zig-zag tubes or parallel tubes}
51/263	. . . . {Flanging}	53/10	. parts of bearings; sleeves; valve seats or the like
51/2638	. . . . {Necking}	53/12	. . cages for bearings
51/2646	. . . {Of particular non cylindrical shape, e.g. conical, rectangular, polygonal, bulged}	53/14	. belts, e.g. machine-gun belts
51/2653	. . . {Methods or machines for closing cans by applying caps or bottoms}	53/16	. rings, e.g. barrel hoops
51/2661	. . . . {Sealing or closing means therefor}	53/18	. . of hollow or C-shaped cross-section, e.g. for curtains, for eyelets
51/2669	. . . {Transforming the shape of formed can bodies; Forming can bodies from flattened tubular blanks; Flattening can bodies}	53/20	. . washers, e.g. for sealing
51/2676	. . . {Cans or tins having longitudinal or helical seams}	53/22	. . . with means for preventing rotation
51/2684	. . . {Cans or tins having circumferential side seams}	53/24	. nuts or like thread-engaging members
51/2692	. . . {Manipulating, e.g. feeding and positioning devices; Control systems}	53/26	. wheels or the like
51/28	. . . Folding the longitudinal seam	53/261	. . {pulleys}
51/30	. . . Folding the circumferential seam	53/262	. . {with inscriptions or the like, e.g. printing wheels}
51/32	. . . . by rolling	53/264	. . {wheels out of a single piece (B21D 53/261 takes precedence)}
51/34	. . . . by pressing	53/265	. . {parts of wheels (B21D 53/28, B21D 53/30 take precedence)}
		53/267	. . {blower wheels, i.e. wheels provided with fan elements}
		53/268	. . {wheels having spokes}

- 53/28 . . gear wheels
- 53/30 . . wheel rims
- 53/32 . . wheel covers
- 53/34 . . brake drums
- 53/36 . clips, clamps, or like fastening or attaching devices,  
e.g. for electric installation
- 53/38 . locksmith's goods, e.g. handles
- 53/40 . . hinges, e.g. door hinge plates
- 53/42 . . keys {(making keys by combined operations  
[B23P 15/005](#)}
- 53/44 . fancy goods, e.g. jewellery products
- 53/46 . haberdashery, e.g. buckles, combs; pronged  
fasteners, e.g. staples
- 53/48 . . buttons, e.g. press-buttons, snap fasteners
- 53/50 . . metal slide-fastener parts
- 53/52 . . . fastener elements; Attaching such elements  
so far as this procedure is combined with the  
process for making the elements
- 53/54 . . . slides
- 53/56 . . . stops
- 53/58 . end-pieces for laces or ropes
- 53/60 . cutlery wares; garden tools or the like
- 53/62 . . spoons; table forks
- 53/64 . . knives; scissors; cutting blades ([B21D 53/72](#)  
takes precedence; handle portions [B21D 53/70](#))
- 53/642 . . . {scissors}
- 53/645 . . . {safety razor blades}
- 53/647 . . . {mower blades}
- 53/66 . . spades; shovels (handle portions [B21D 53/70](#))
- 53/68 . . rakes, garden forks, or the like (handle portions  
[B21D 53/70](#))
- 53/70 . . handle portions ([B21D 53/72](#) takes precedence)
- 53/72 . . sickles; scythes
- 53/74 . frames for openings, e.g. for windows, doors,  
handbags
- 53/745 . . {Joining mitred profiles comprising punching the  
profiles on a corner-angle connecting piece}
- 53/76 . writing or drawing instruments, e.g. writing pens,  
erasing pens
- 53/78 . propeller blades; turbine blades
- 53/80 . dustproof covers; safety covers
- 53/82 . perforated music sheets; pattern sheets, e.g. for  
control purposes, stencils
- 53/84 . other parts for engines, e.g. connecting-rods
- 53/845 . . {Making camshafts}
- 53/86 . other parts for bicycles or motorcycles
- 53/88 . other parts for vehicles, e.g. cowlings, mudguards
- 53/883 . . {reflectors}
- 53/886 . . {leaf springs}
- 53/90 . . axle-housings
- 53/92 . other parts for aircraft

**55/00** Safety devices protecting the machine or the  
operator, specially adapted for apparatus or  
machines dealt with in this subclass (for presses in  
general [B30B](#); safety devices in general [F16P](#))